

5/46

DART AEROSPACE LTD	Work Order:	24709
	Part Number:	D3162-041
Description: Bracket assembly.		Stack of 7
Drawing: D3162 Rev. A/S RF 04-11-29	Qty:	15 19

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order	JH	05.10.26	15
2	METAL / CNC-CELL	Cut Blanks. Blank size: 1.150" x 0.985" x .063" thick. Grain along .985 Matl: 6061-T6 .063" thick (M6061T6S.063)	JL	05.11.12	19
3	HAAS	Machine as per Folio FA239 Stack of 7 Batch M18556	JL	05.11.12	19
4	QC	Inspect Level 2	JL	05.11.13	19
5	QC	Inspect Level 8	JL	05.11.13	19
6	METAL / CNC-CELL	Deburr break all unmarked sharp edges .005 to 0.010	SAD	05/11/13	19
7A	METAL	Form as per drawing	SPB	05/11/14	19
7B	6A	C'sink holes as per Dwg D3162	FF	05/11/15	19
8	FINISHING	Chemical conversion coat as per QSI 005 4.1	FF	05/11/15	19
9	STORES	Pick: Qty Part Number Description Batch 1 MS21059L3 Nutplate M12240 2 MS20426AD3-4 Rivet M15786	FF	05/11/15	19
10	METAL	Assemble as per drawing	FF	05/11/15	19
11	QC	Inspect Level 5	JL	05.11.16	19
12	STORES	Identify and stock with P/N + B/N using fine point permanent ink marker	LC 88	05/11/16	19
13	EXPEDITING	Close W/O Inspect level 21 Cost/part .99 545 05/11/21 19	QD	05/11/21	19

Rev	Date	Change	Revised By	Approved
A	02.05.14	New Issue	NG	CE 2002/5/2002
A1	03.03.20	Added c'sink	RF	CE 2002/5/2002

RELEASED

02/05/14

CJ

RF
04.11.29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 05/11/21
 QA: N/C Closed: _____ Date: _____

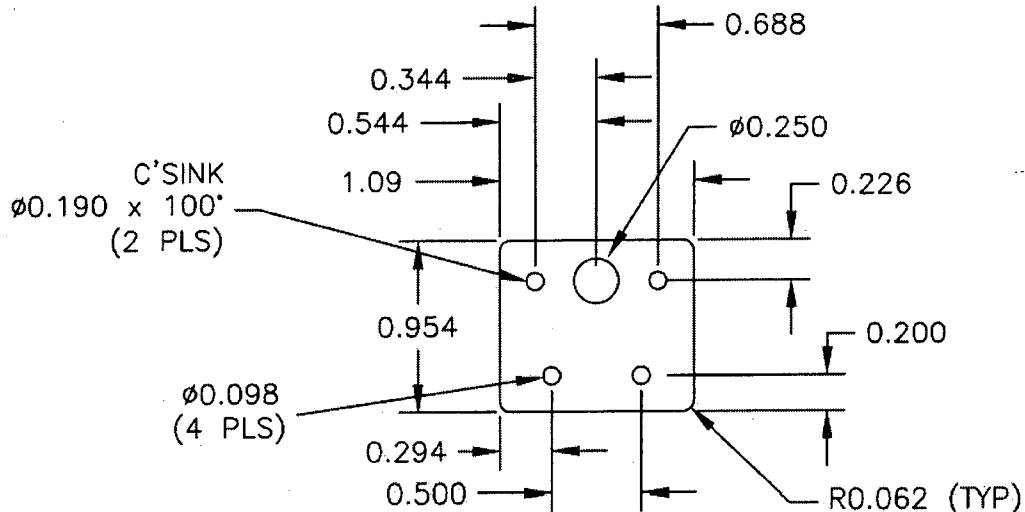
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

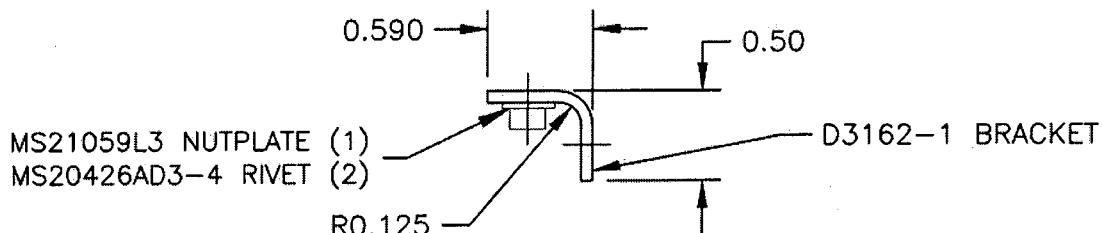


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3162	SHEET 1 OF 1
DATE		TITLE	SCALE
04.10.18		BRACKET ASSEMBLY	1:1
A	02.04.30	NEW ISSUE	
B	04.10.18	ADD PART MARKING	

RELEASED
04.11.23



D3162-1 BRACKET FLAT PATTERN



D3162-041 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

JUL 04 2004
SUBJECT: D3162-041
WITH 1C

WORK ONLY
NO. 24709

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 26, 2005
03:12 pm

Work Order No : 0024709
 Project Name : D3162-041
 Project For : WK546
 Work Order Type : Main
 Main WO Number :
 House Part Number : D3162-041
 Description : Bracket Assembly
 Manufactured : Yes
 Amount Req'd : 15
 Amount Done : 0
 Start Date : 10-26-05
 Est Finish Date : 11-15-05
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Mark Up : 0.000%
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
===== ===== =====					
Burden :	0.00	0.00	0.00	0.00	0.00
===== ===== =====					
Total Cost :	0.00	0.00	0.00	0.00	0.00
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD	Work Order:	24709
Description: bracket assembly	Part Number:	A3162-041
Inspection Dwg: A3162	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article

1

Prototype

Measured by:	JL	Audited by:	ml	Prototype Approval:	
Date:	05.11.13	Date:	05/11/13	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	

Date: Thursday, 11/17/2005 6:02:22 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: BRACKET ASSEMBLY		
Job Number	: 24709						
Estimate Number	: 10688						
P.O. Number	:			Part Number	: D3162041		
This Issue	: 11/17/2005 S.O. No. :			Drawing Number	: D3162 REV B		
Prsht Rev.	: NC			Project Number	:		
First Issue	: / / Type : MACHINED PARTS			Drawing Revision	: B		
Previous Run	: 24688			Material	:		
Written By	:			Due Date	: 11/24/2005 Qty: 19 Um: Each		
Checked & Approved By	:						
Comment	: Est A 02.05.14 New Issue NG						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S063	6061-T6 .063 Sheet
2.0	BAND SAW	BAND SAW
	Comment: BAND SAW	
	Cut Blanks. Blank size: 1.150" x 0.985" x .063" thick. Grain along .985	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1	
	Machine as per Folio FA239 Stack of 7	Batch _____
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1	
	Deburr break all unmarked sharp edges .005 to 0.010	
	Form as per drawing	
	C'sink holes as per Dwg D3162	

Date: Thursday, 11/17/2005 6:02:23 PM
User: Linda Lacelle

Customer: CU-DAR001 Dart Helicopters Services

Process Sheet

Drawing Name: BRACKET ASSEMBLY

Job Number: 24709

Part Number: D3162041

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0 MS21059L3

Nut Plate

9.0 MS20426AD34

RIVET

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per drawing

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: _____

13.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

